

Work Order ID 52534

September 29, 2009 12:53:32 PM



Page 1

Item ID: D3847-045 **GY**
Revision ID: B
Item Name: CENTER WEARPLATE ASSY, STD/FLOAT

Accept



Setup Start



Stop



Start Date: 09/30/2009 Start Qty: 2.00
Required Date: 10/12/2009 Req'd Qty: 2.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: mf Date: 09-09-29 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3847	B								
100		0.00							
	Waterjet								
FLOW CNC Waterjet	Memo 1-Cut as per Dwg D3847 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary	0.00							<u>IB 9-9-30</u>
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							<u>IB 9-9-30</u>

(4)

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Item ID: D3847-045

Accept



Setup Start



Revision ID: B

Stop



Item Name: CENTER WEARPLATE ASSY, STD/FLOAT

Start Date: 09/30/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

2) 509/10/130



130



Brake NC

Brake NC

Memo
form as per dwg D3847

0.00

0.00

2) 509/10/105



140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) 509/10/105



00000000000000000000000000000000

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Accept

Setup Start

Stop

Abstract

Cust Item ID:

Customer:

Reference:

Run Start

Stop

Stop

**Insp.
Stamp**

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Grey Sandtex (Ref. 4.5.5.6) per Q51005 4.5

M/109091

START 1.05

MEMO OVEN TEMP. 300°

FINISH 1.35

0.00

Powdercoat

Powder Coating

160

QC3- Inspect Part Finish

0.00

Abstract

QC

Memo

0.00

Quality Control

170

0.00

Abstract

Small Fab

Memo

0.00

Small Fab

1- Bond gasket to inner surface of wearplate using a thin layer of 3M 1300/1300L scotch grip adhesive as per dwg D3847






BATCH: 1711428



Work Order ID 52534




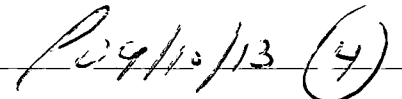


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Page 4

Item ID: D3847-045 Accept  Setup Start 
Revision ID: B Stop 
Item Name: CENTER WEARPLATE ASSY, STD/FLOAT
Start Date: 09/30/2009 Start Qty: 2.00  Cust Item ID:
Required Date: 10/12/2009 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<i>27 Sep 10/13</i> 
190  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							<i>09/10/13 (4)</i> 
200  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>09/10/19</i> 

U 09-10-16

Picklist Print

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Page 1

Work Order ID: 52534

Parent Item: D3847-045RevB

Parent Item Name: CENTER WEARPLATE ASSY, STD/FLOAT

Start Date: 09/30/2009

Required Date: 10/12/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3846-5RevB GASKET		Manufactured	No				Each	8.0000	2.0000			

Warehouse Location				Loc Qty	Loc Code	
Main Warehouse						
FP				8		
51828				8		
M304S18GA		Purchased	No			
304/316 .050 Sheet				sf	154.6396	0.2044

Warehouse Location				Loc Qty	Loc Code	
Main Warehouse						
MAT				154.6396053		
108156				0.98526316		
111743				23.7174		
112178				129.936942		

B51828 (2x)
 B52678 (2x)
 9/30/09/13
 3.400
 189-9-30

DART AEROSPACE LTD	Work Order:	52534
Description: CENTER WEAR PLATE	Part Number:	D3847-645
Inspection Dwg: D3847-5 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

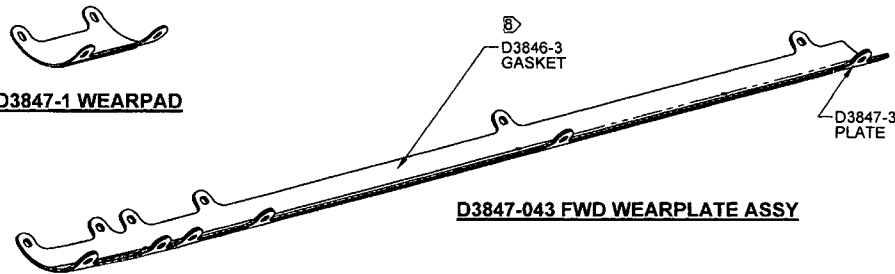
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[illegible]

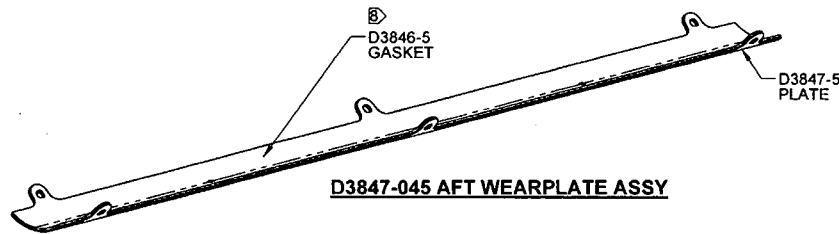
Measured by:	IB	Audited by:	J	Prototype Approval:	N/A
Date:	9-9-30	Date:	09/02/36	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

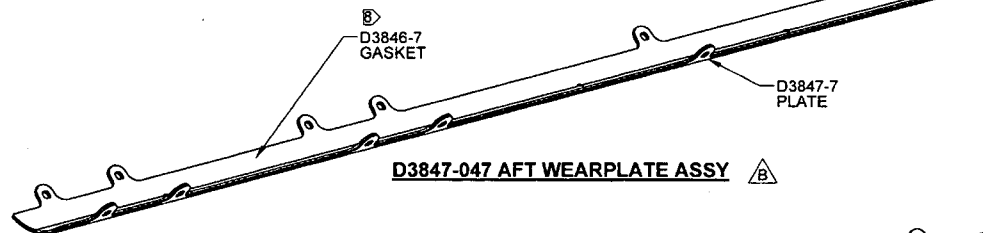
D3847-1 WEARPAD



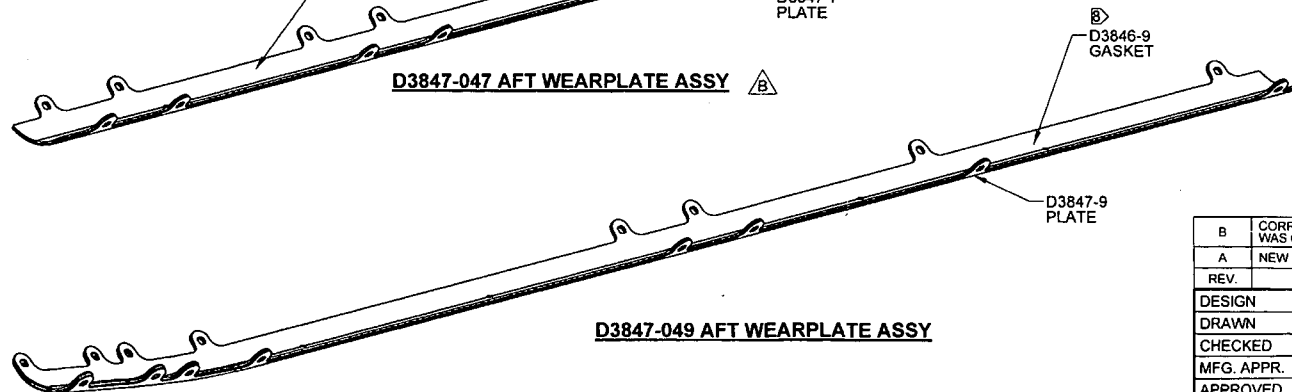
D3847-045 AFT WEARPLATE ASSY



D3847-047 AFT WEARPLATE ASSY



D3847-049 AFT WEARPLATE ASSY



ITEM	QTY -043	QTY -045	QTY -047	QTY -049	P/N	DESCRIPTION
1	X				D3847-043	FWD WEARPLATE ASSY, STD/FLOAT GEAR
2		X			D3847-045	CENTER WEARPLATE ASSY, STD/FLOAT GEAR
3			X		D3847-047	AFT WEARPLATE ASSY, STD GEAR
4				X	D3847-049	AFT WEARPLATE ASSY, FLOAT GEAR
11	1				D3847-3	PLATE
12		1			D3847-5	PLATE
13			1		D3847-7	PLATE
14				1	D3847-9	PLATE
15	1				D3846-3	GASKET
16		1			D3846-5	GASKET
17			1		D3846-7	GASKET
18				1	D3846-9	GASKET
31	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

NOTES:

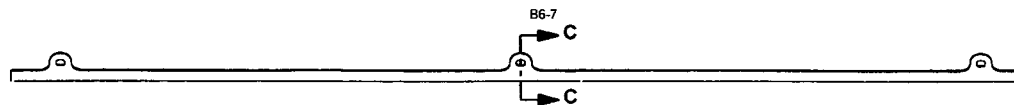
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-XXX" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3847-043 = 1.71 lbs
D3847-045 = 1.49 lbs
D3847-047 = 2.00 lbs
D3847-049 = 4.21 lbs
- 8) BOND D3846-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

D3847-11 WEARPAD

RELEASED
09/07/15

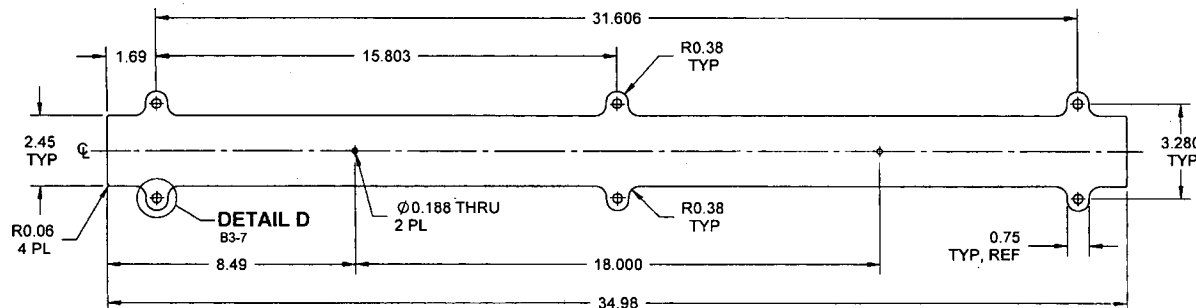
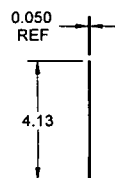
B	CORRECT TYPO D3847-047 WAS D3847-045, ZN B5-1; 5.82 WAS 6.25 (ZN A4-2); 45.28 WAS 45.71 (ZN B4-5)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3847	SHEET 1 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



D3847-5 PLATE
MADE FROM D3847-5F FLAT PATTERN

52534



D3847-5F FLAT PATTERN

NOTES:

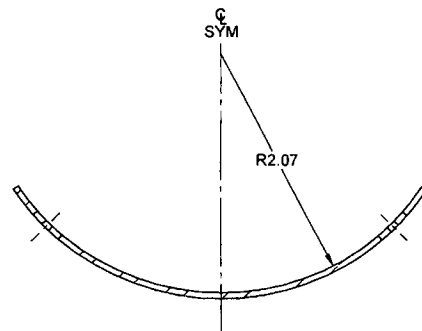
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 18 GAUGE (0.050 THICK), (REF. DART SPEC. M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.29 lbs

RELEASED
9/6/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO. D3847	REV. B
MFG. APPR.	RF	TITLE	SHEET 4 OF 7
APPROVED	RF	WEARPLATE ASSY	SCALE
DE APPR.	RF	DATE	NTS
		09.06.30	

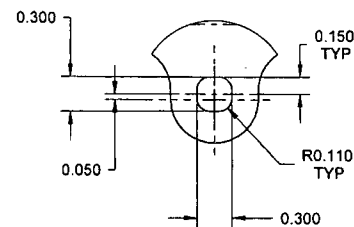
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8 7 6 5 4 3 2 1



SECTION C-C
SCALE 4X

D4-3
D4-4
D3-5
D3-6



DETAIL D
TYP, SCALE 4X

B5-3
B5-4
B3-5
B5-6

RELEASED
09/07/15

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. D3847	REV. B SHEET 7 OF 7
MFG. APPR.	<i>FE</i>	TITLE	SCALE
APPROVED		WEARPLATE ASSY	NTS
DE APPR.	<i>RF</i>	DATE 09.06.30	
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